



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C45-15
Job Sheet 185602



Part No: C45-15

Job Qty: 4 ea

Part Name: Keeperless Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 11/9/18

Created By: Linda Lacelle

Type: AOG

Description:

Note: DWG C45-15 Rev 3 IPP Rev A 18.03.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-2		
110	CNC Vertical Machining	4 pcs	11/9/18	11/9/18	0.00	4.00	MORI NV5000-1		} See next page for signatures
120	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-4		
130	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-4		
140	Outsource - 1 - Heat Treat	4 pcs	11/9/18	11/9/18			ATL002-VC		
150	Outsource	4 pcs	11/9/18	11/9/18	0.00	0.00	Outsource15		
160	Packaging	4 pcs	11/9/18	11/9/18	0.00	0.00	Packaging2		NOV 21 2018
170	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC6		36
180	Packaging	4 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		21 NOV 21 2018
190	QC21-SA	4 Ea	11/9/18	11/9/18	0.00	0.00	QC21		

Part Op 110 - 1-Cut blanks to 3.5" 2- ***See PEC for batch# to be programmed*** 3-Machine as per DWG. FC299 FOLIO REV: Descriptions: _____ DWG REV: _____ 4-Deburr

140 - 1-Issue P/O to ATLANTIC HEAT TREAT; P/O _____ RC _____ 2-Bead blast 3--Material type; 4140 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER

150 - -Issue P/O to Groupe Altech: P/O 004451 -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-2.000X2.500	4140 Steel Bar 2.000 X 2.500	1.1780 ft (.2945 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-B-2.000X2.500	1	6	0

Part Specifications

Specifications could not be found.

DOA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								



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Canada

Tel (613) 632-5200
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C45-15

Job Sheet 185602



Part No: C45-15

Job Qty: 4 ea

Part Name: Keeperless Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 11/9/18

Created By: Linda Lacelle

Type: AOG

Description:

Note: DWG C45-15 Rev 3 IPP Rev A 18.03.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-2		AS 18-11-01
110	CNC Vertical Machining	4 pcs	11/9/18	11/9/18	0.00	4.00	MORI NV5000-1		J.C.L.
120	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-4		J.C.L. 18-11-03
130	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-4		D.P. 18-11-03
150	Outsource	4 pcs	11/9/18	11/9/18	0.00	0.00	Outsource15		ETK 18-11
160	Packaging	4 pcs	11/9/18	11/9/18	0.00	0.00	Packaging2		
170	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC6		
180	Packaging	4 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		
190	QC21-SA	4 Ea	11/9/18	11/9/18	0.00	0.00	QC21		

Part Op 110 - 1-Cut blanks to 3.5" 2- ***See PEC for batch# to be programmed*** 3-Machine as per DWG. FC299 FOLIO REV:
Descriptions: AA DWG REV: 3 4-Debur
150 - -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-
.0006 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-2.000X2.500	4140 Steel Bar 2.000 X 2.500	1.1680 ft (.292 ea)	90-Start up Operation	5058 399

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-B-2.000X2.500	1	12	0

Part Specifications

Specifications could not be found.

Plex 10/31/18 7:41 AM dart.lacelle.linda



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S123093



Part: C45-15

Job No: 185602

Serial No/Batch: S123093

Revision: 3

Inspector:

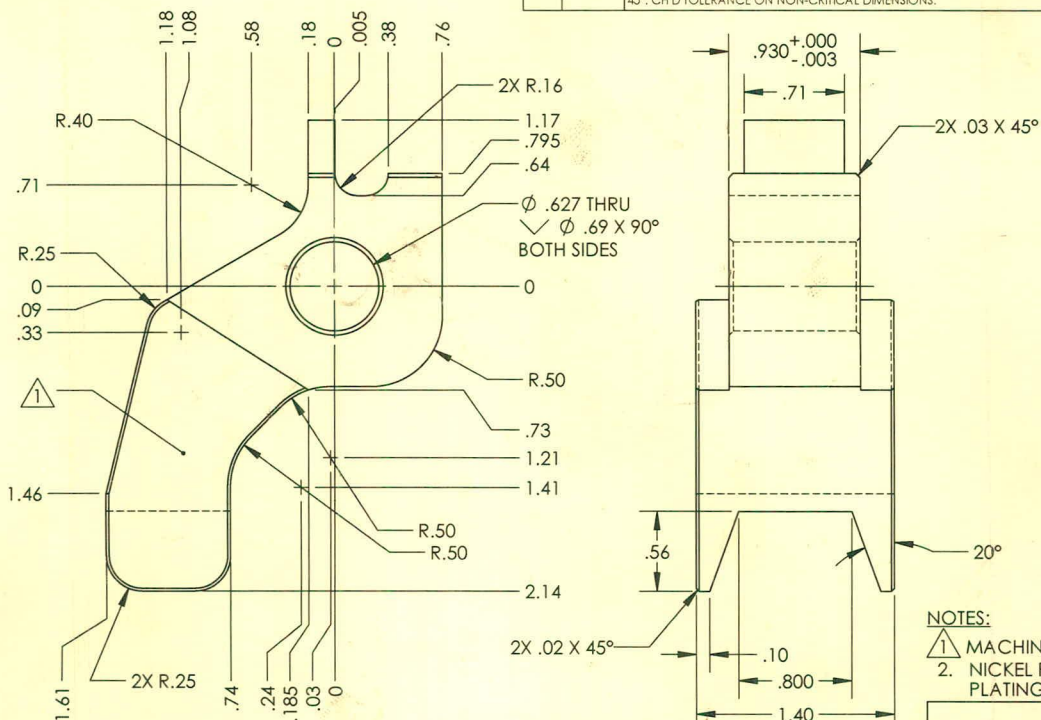
Exp Date:

Instructions:

Date: 10/31/18

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2		AS DRAWN BY CANAM.	9/17/12	RJC
3	14-0137	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE. CH'D DIMS WAS .797 IS .795, WAS 1.203 IS 1.21, WAS .716 IS .71, WAS .323 IS .33, WAS 1.453 IS 1.46. ADDED DIM 2X .03 X 45°. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/20/2014	DPD



NOTES:

1. MACHINE ENGRAVE BATCH NUMBER.
2. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.

DART AEROSPACE	
TITLE KEEPERLESS ADAPTER	
DWG NO. C45-15	REV 3
MAT'L 4140	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005	HEAT RC 44-46
.XX ± .01	TREAT SEE NOTE 2
.X ± .1	FINISH
ANGLES ± 5°	SPEC
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 5/21/2002
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-15	1	KEEPERLESS ADAPTER	4140	1-1/2 X 2-1/2 X 3-7/16



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER **PO041630**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO041630
PO Date: 11/6/18
Due Date: 11/16/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185602	C45-15	1-Issue P/O to ATLANTIC HEAT TREAT; P/O _____ RC 2-Bead blast 3-Material type; 4140 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO GROUPE ALTECH	Firmed	-	11/16/18	4 pcs	0 pcs	4 pcs	\$40.00/pcs	\$160.00

Line Item Note URGENT **need a day turn over **



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Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER **PO041630**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	185221	269T9281	Wrench, Splined Fitting HEAT TREAT TO RC 25-32 1-Issue P/O to Atlantic; P/O _____ RC _____ 2-Bead blast 3- Certificate of Conformity is required -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	11/16/18	6 pcs	0 pcs	6 pcs	\$35.75/pcs	\$214.50
3	177795	RBEM652V3002101-M-7	Stud 1-Issue P/O to Atlantic; P/O _____ RC 35-45 2-Bead blast 3- Certificate of Conformity is required -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/16/18	6 pcs	0 pcs	6 pcs	\$35.75/pcs	\$214.50

Grand Total: \$589.00



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
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PURCHASE ORDER
PO041630

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/14/18 1:57 PM dart.tsimiklis.chrisoula

Atlantic Heat Treating (2001) Ltd

Order No.: 160244

Ship Date: 9/11/2018

Shipping Ticket

Sold To:
DART AEROSPACE LTD.
1270 ABERDEEN ST

1448

HAWKESBURY ON K6A 1K7

Ship To:
DART AEROSPACE LTD.
1270 ABERDEEN ST

157356

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
PO041630				

Quantity	Part No. / Part Name / Part Description	Pounds
----------	---	--------

4 PCS MATERIAL 4140
ANNEAL & HEAT TREAT TO 44-46RC
SAND BLAST, C OF C, PRT# C45-15, JOB#185602

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

4

Pounds Shipped:

4.00

Order No.: 160244

Shipped Complete

Quantity Shipped:

4.00

Received By:

Date:

Pounds Shipped:

4.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 11/09/2018

Certification

Date: 11/13/2018

Entry Date: 11/09/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: PO041630

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
4	4 PCS MATERIAL 4140 ANNEAL & HEAT TREAT TO 44-46RC SAND BLAST, C OF C, PRT# C45-15, JOB#185602	4

Insp. Type	Scale	Minimum	Maximum	Number	Other
Customer Requirements:					

Harden rockwell

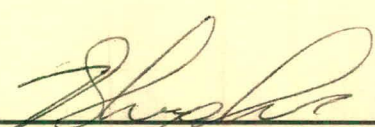
Results:

Harden ROCKWE	44.	46.	45. TESTED AS PER SAMPLING PLAN
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HEAT TREATED TO 45 RC AS PER CUSTOMER REQUEST

DAS
38
9-89

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY): ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE FOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041751**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041751
PO Date: 11/16/18
Due Date: 11/20/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments: ** Please confirm fastest ETA **

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185602	C45-15	Keeperless Adapter -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 - Certificate of Conformity is required	Firmed	-	11/20/18	4 pcs	0 pcs	4 pcs	\$30.00/pcs	\$120.00

4 X

NOV 21 2018

DAS
38
9-89

Line Item Note ** please confirm quickest ETA **

Grand Total: \$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

241
05
241



Certificat de Conformité / Certificate of Compliance

(014513-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014513- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
19-Nov-2018		Aman		041751 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	C45-15-6 ✓ Rev.	C45-15-6 01 -E-NIC STEEL 500 [E-NICKEL STEEL 500] QQ-N-290 CLASS 2 GRADE E OR F NICKEL PLATE TO 0.0004-0.0006 THICK	E-NICKEL STEEL CH	4	4 ✓	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

40
33
10-6